

Work Order ID 117436

117436

Page 1

May-23-14 10:12:59 AM

Item ID: D2521

Revision ID:

Item Name: Individual Bearpaw

Start Date: 5/08/14 Start Qty: 12.00

Required Date: 5/08/14 Req'd Qty: 12.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: *ca*

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2521	Rev J								

105

0.00

105

Purchasing

Purchasing

Memo

ISSUE PO

24350

Cut Blank as per D2521 blank file

0.00

CL 14/05/26 12

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Packaging

Memo

0.00

12X 14-6-10

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Quality Control

Memo

0.00

DAS

27

9-89

4/6/10

12

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[illegible]

Work Order ID 117436

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117436

Page 3

Item ID: D2521 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Individual Bearpaw
 Start Date: 5/08/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/08/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00				12X	DAS 28 9-89		JUN 23 2014
Packaging									
170	QC21 - Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00				MLD	14-20-24		
Quality Control									

ME
14-6-23

Picklist Print

May-23-14 10:12:58 AM

Page 1

Work Order ID: 117436

117436

Parent Item: D2521

D2521

Parent Item Name: Individual Bearpaw

Start Date: 5/08/14

Required Date: 5/08/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	400.0000		89			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

CL 14/05/28

Location

Loc Qty

Loc Code

MAT018

400

m128267

47

m128668

353

m129293

DART AEROSPACE LTD		Work Order: 117436
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260	✓		MH-04	Caliper
B	0.90	0.96	.933	✓			
C	0.27	0.330	.306	✓			
D	0.470	0.530	.500			MH-06	Depth gauge
E	21.740	21.760	21.750	✓		MH-07	Tape
F	0.72	0.780	.750	✓		MH-04	Caliper
G	0.35	0.410	.378	✓			
H	11.490	11.570	11.50	✓		MH-09	Tape
I	3.41	3.47	3.44	✓			
J	11.790	11.810	11.800	✓			
K	9.47	9.53	9.50	✓			
L	7.190	7.210	7.200	✓			
M	6.910	6.970	6.940	✓			
N	44.47	44.530	44.500	✓			
O	6.590	6.650	6.62	✓			
P	0.940	0.980	.975	✓		MH-04	Caliper
Q	18.97	19.03	19.00	✓		MH-07	Tape
R	0.350	0.410	.385	✓		MH-04	Caliper
S	0.740	0.780	.753	✓			
T	0.240	0.280	.250	✓			
U	0.370	0.410	.381	✓			
V	0.740	0.780	.753	✓			
W	0.740	0.780	.767	✓			

Measured by: MH -	Audited by: DAS 20	Prototype Approval:	N/A
Date: 14/06/18	Date: 14-06-20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

DART

DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

11743645
140424**RELEASED**

06 08.23 [Signature]

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DART

DESIGN

DRAWN BY

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

REV. J

D2521

SHEET 2 OF 3

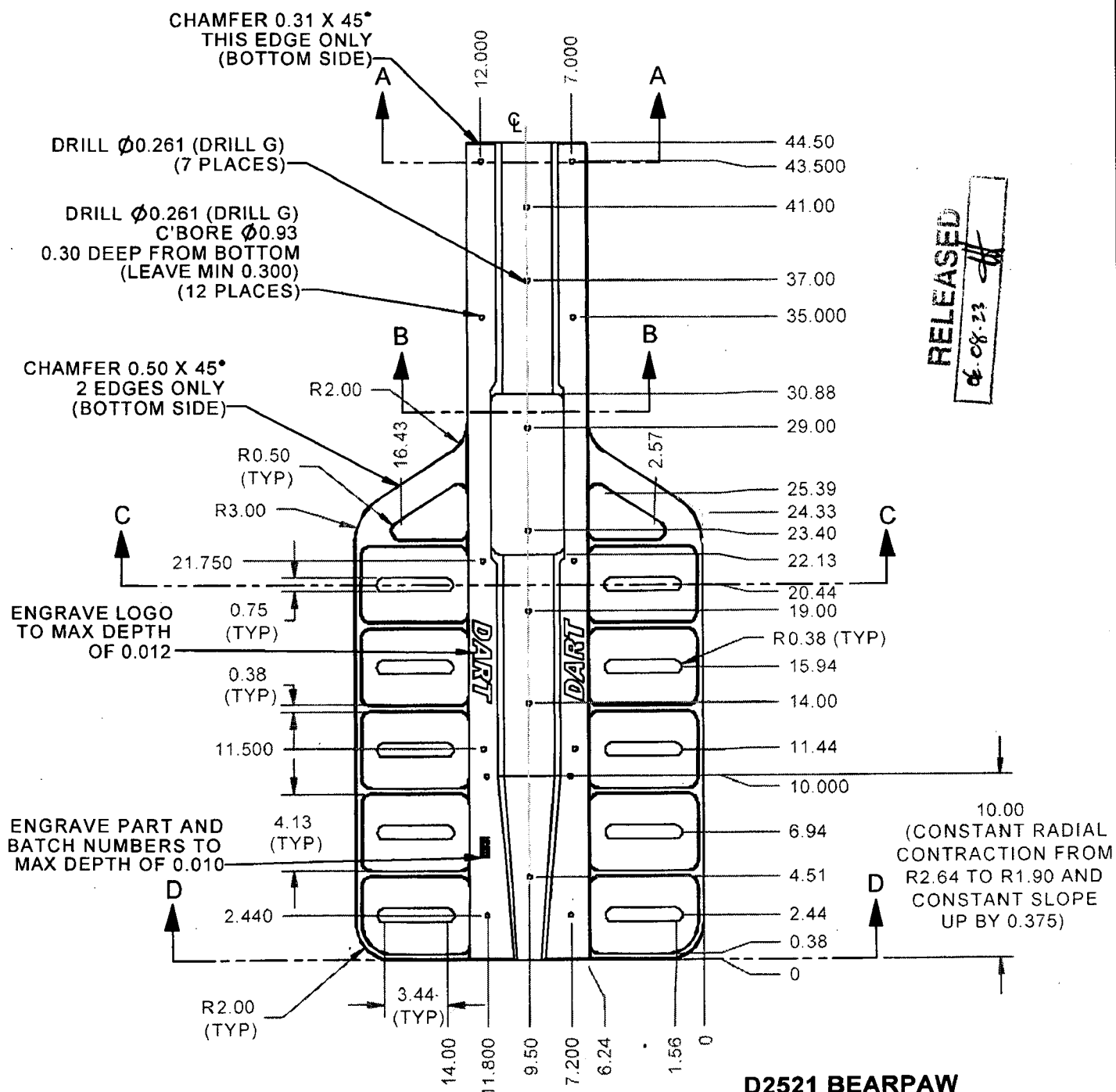
DATE

TITLE

SCALE

06.07.28**205 BEARPAW**

1:8

**D2521 BEARPAW****NOTES:**

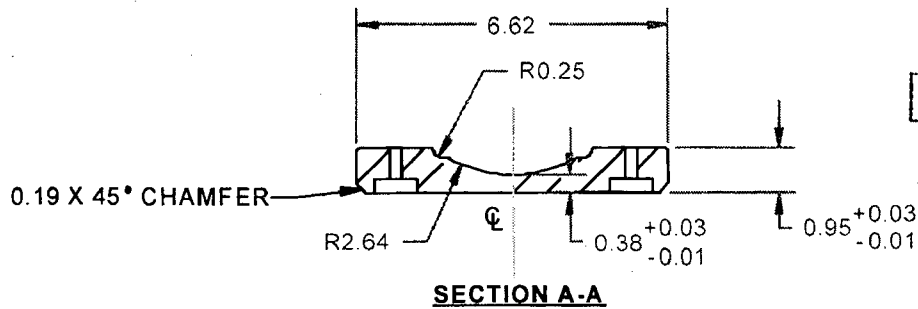
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

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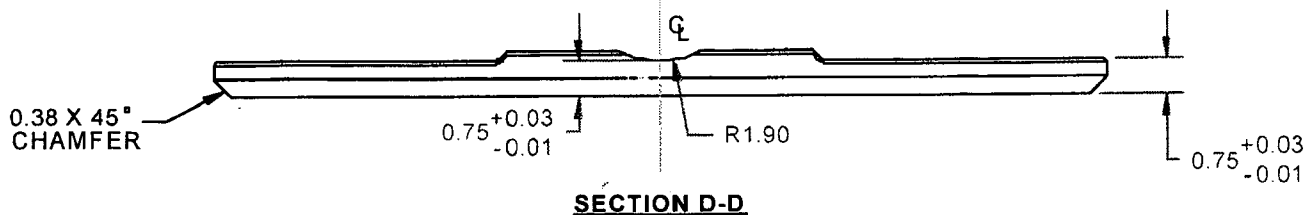
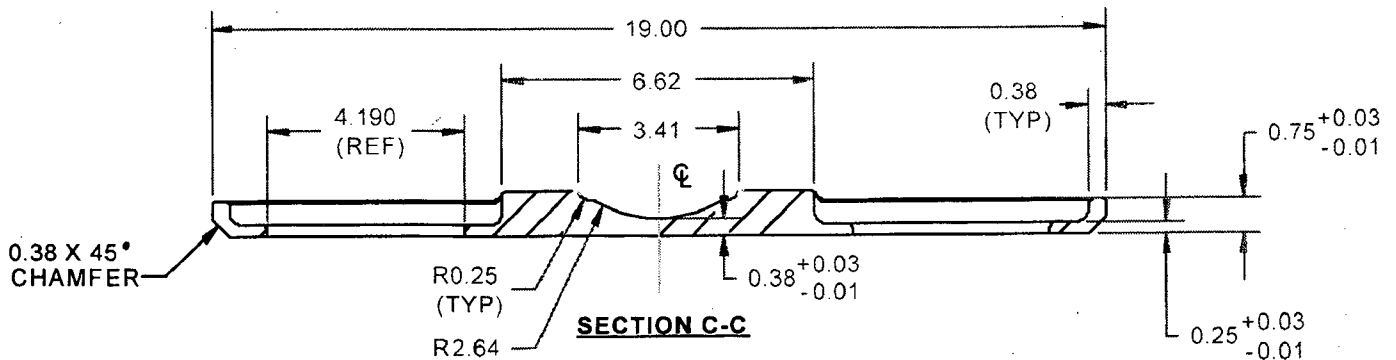
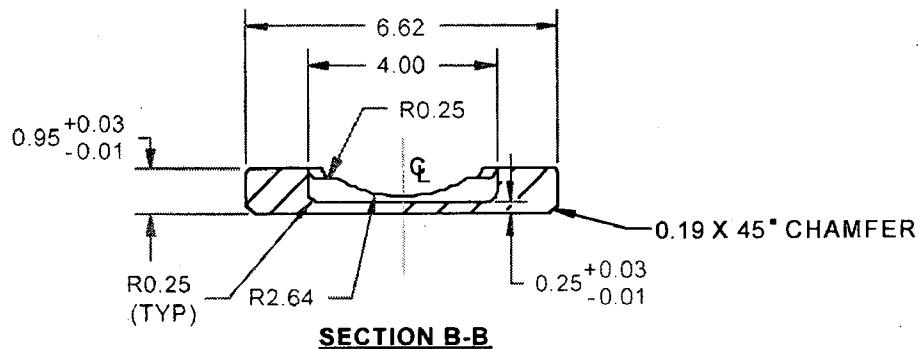
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DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW		SHEET 3 OF 3
			SCALE 1:4

**RELEASED**

06.08.23 #

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24350**

Purchase Order Date 5/26/2014

PO Print Date 5/26/2014

Page Number 2 of 4

Order From :

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

VC-TPI001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-633-0484

Ship To Contact

Ship To Phone

Ship Via:

Day & Ross collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total:

\$349.

4 117436

D2521 BEARPAW

6/13/2014

12.00 ✓

\$55.36

\$664.

Yes

6/13/2014

CUT BLANK AS PER FILE

Line Total:

\$664.

5 115766

D2671 BEARPAW

6/13/2014

4.00 ✓

\$24.42

\$97.

Yes

6/13/2014

CUT BLANK AS PER FILE

Line Total:

\$97.

6 117867

D2916-1 CABLE GUARD

6/13/2014

8.00 ✓

\$21.70

\$173.

Yes

6/13/2014

CUT BLANK AS PER FILE

Line Total:

\$173.

SP14-6-10

Note:

5/26/2014